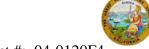
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-001740 Address: 333 Burma Road **Date Inspected:** 16-Mar-2008

City: Oakland, CA 94607

OSM Arrival Time: 1830 **Project Name:** SAS Superstructure **OSM Departure Time:** 730 Prime Contractor: American Bridge/Fluor Enterprises, a JV

Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island Contractor: **Location:** Shanghai, China

CWI Name: CWI Present: Yes No NA **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Oualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No **Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component:** u-rib deck panel

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and orthotropic box girders (OBG), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

WBS Item Description Status Dwg No. deck plate u-rib NA NA ZPMC QC MT

OBG Bay 1: ZPMC presented ZPMC Notification of witness inspection for magnetic particle testing of final weld DP083-001-012 at 1920 hours. Caltrans QA witnessed ZPMC QC perform magnetic particle (MT) on fillet weld, diaphragm plate joining u-rib, weld identified as 012. The ZPMC QC inspector is identified as Mr. Zhou Dongyan. Caltrans observed that the QC MT coverage was 100% and performed in conformance with the contract specifications. The following digital picture illustrates ZPMC MT inspection in progress.

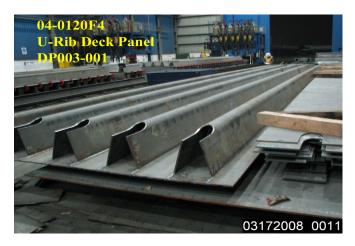
WELDING INSPECTION REPORT

(Continued Page 2 of 3)



NA NA OA VT u-rib deck panel

OBG Bay 1: Caltrans QA Inspector performed visual inspection of the completed submerged arc welding (SAW) cover pass welds; partial joint penetration (PJP) welds joining the closed ribs to deck plate panel DP042-001, u-rib U150, welds 1 & 2; u-rib U138, weld 3 and DP003-001, u-rib U122, welds 9 & 10 and u-rib U145 weld 8. Caltrans QA observed welding overlap, over size welds, underfill and incomplete fusion. These indications observed at the weld were marked in yellow paint stick along the distance from the "Y" axis, starting at the weld start too weld completion end. The weld indications observed were recorded on Caltrans spreadsheet for future reference. The following digital pictures illustrate u-rib deck plate panel DP003-001.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Hasler, Mike **Inspected By:** Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Cuellar,Robert QA Reviewer